


A2412700

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SECTION A - A

1. MAKE FROM MDC'S ROTATABLE VACUUM FLANGE CAT. #100008
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - A) CIMCOOL 5 STAR 49
 - B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGULAR .X - .03 (.7620) - .25 .XX - .01 (.025) .XXX - .005 (.127)		THIS DRAWING IS THE PROPERTY OF  ARGONNE NATIONAL LABORATORY		
SURFACE ROUGHNESS 125 REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DRAWN BY: MUSCIA CHECKED BY: D. SHU DESIGNER: SHU/MUSCIA RESPONSIBLE ENGINEER: D. SHU MATERIAL: SEE NOTE #1 DATE: 10/12/95 CHIEF DESIGN ENGINEER: D. SHU GP LEADER: T.M. KUZAY PROJECT MGR.: APPROVED/RELEASED: DATE: 6/23/96 SCALE: 1:1 SIZE: C SHEET: 1 of 1 DRAWING NUMBER: P4105091502-910205-00		
DO NOT SCALE DRAWING				